

5/05

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22234
<b>Description: Arm</b>	<b>Part Number:</b>	<del>D2802-1</del>
<b>Dwg:</b> D2802 rev <del>A</del> <i>B</i> <i>D3387 Rev A</i> <i>(P05.01.25)</i>	<b>Qty:</b>	<i>74</i>

*05-01-18*

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>AD</i>	05.01.17	2
2	METAL	Cut blanks <del>16.300</del> <i>17.800</i> " long Material: 6061-T6 bar 6.00" x 0.50" Batch: <i>M9601</i> <i>011409</i> <i>M11708</i>	<i>AD</i>	05.01.18	<i>4</i>
3	HAAS	Machine as per folio FA101	<i>SD</i>	05.01.18	<i>4</i>
4	CNC-CELL	Counter sink .375 dia as per dwg	<i>AD</i>	05.01.18	<i>4</i>
5	QC	Inspect Level 2	<i>SD</i>	05.01.18	<i>4</i>
6	QC	Inspect Level 8	<i>EC</i>	05.01.20	<i>4</i>
7	METAL	Tumble & Deburr <b>NO</b> sharp edges.	<i>AD</i>	05.01.20	<i>4</i>
8	QC	Inspect Level 5	<i>EC</i>	05.01.20	<i>4</i>
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	<i>PD</i>	05.01.20	<i>4</i>
10	STORES	Identify and stock	<i>PD</i>	05.01.20	<i>4</i>
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <i>55.11</i> <i>545</i> <i>05/01/21</i> <i>(4)</i> <i>97.81</i>	<i>AD</i>	05.01.21	<i>4</i>

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	<i>02-03-18</i>

**RELEASED**

*02/03/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.01.18	2	Permanent change	<i>[Signature]</i>	05.01.18	N/A	<i>[Signature]</i> per change	<i>[Signature]</i> 05.01.26

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.19	3	1 piece scrap 1 time run the program wrong dwg (wall wrong)	<i>[Signature]</i> per change	destroy & replace	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19

Part No: 3387-1 ~~D2802~~ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/01/2019

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

PART AEROSPACE LTD		Work Order: 222 34
Description: Arm		Part Number: 02802-1
Inspection Dwg: D2802 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	$\pm 0.01$	0.506	✓			
1.700	"	1.703	✓			
0.188	"	.189	✓			
Ø.507	$\pm 0.000$ $-0.001$	Ø.506	✓			
2.033	$\pm 0.005$	2.028	✓			
Ø.191	$\pm 0.005$ $-0.000$	Ø.192	✓			
2.000	$\pm 0.01$	2.003	✓			
1.347	"	1.347	✓			
Ø.507	$\pm 0.000$ $-0.001$	Ø.507	✓			
Ø.250	$\pm 0.01$	Ø.251	✓			
R.125	"	R.125	✓			
16.245	"	16.248	✓			
7.577	"					
0.250	"	.250	✓			
<del>Ø.125 ±0.01 Ø.125 ✓</del>						
0.500	"	.500	✓			
.135	$\pm 0.020$ $-0.000$	.149	✓			
.280		.282	✓			
SCRAP						PROBLEM w/ Eng dwg needs thicker walls. SCRAP 1st part. Make with thicker walls per marked-up dwg 05.01.18

Measured by: SD	Audited by: E	Prototype Approval:
Date: 05/01/18	Date: 05.01.18	Date:
Rev A	Date	Change
		New Issue
Revised by	Approved	
KJ/JLM		

BART AEROSPACE LTD		Work Order: 22234
Description: ARM		Part Number: <del>D2801</del> D3387+1
Inspection Dwg: D2801 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

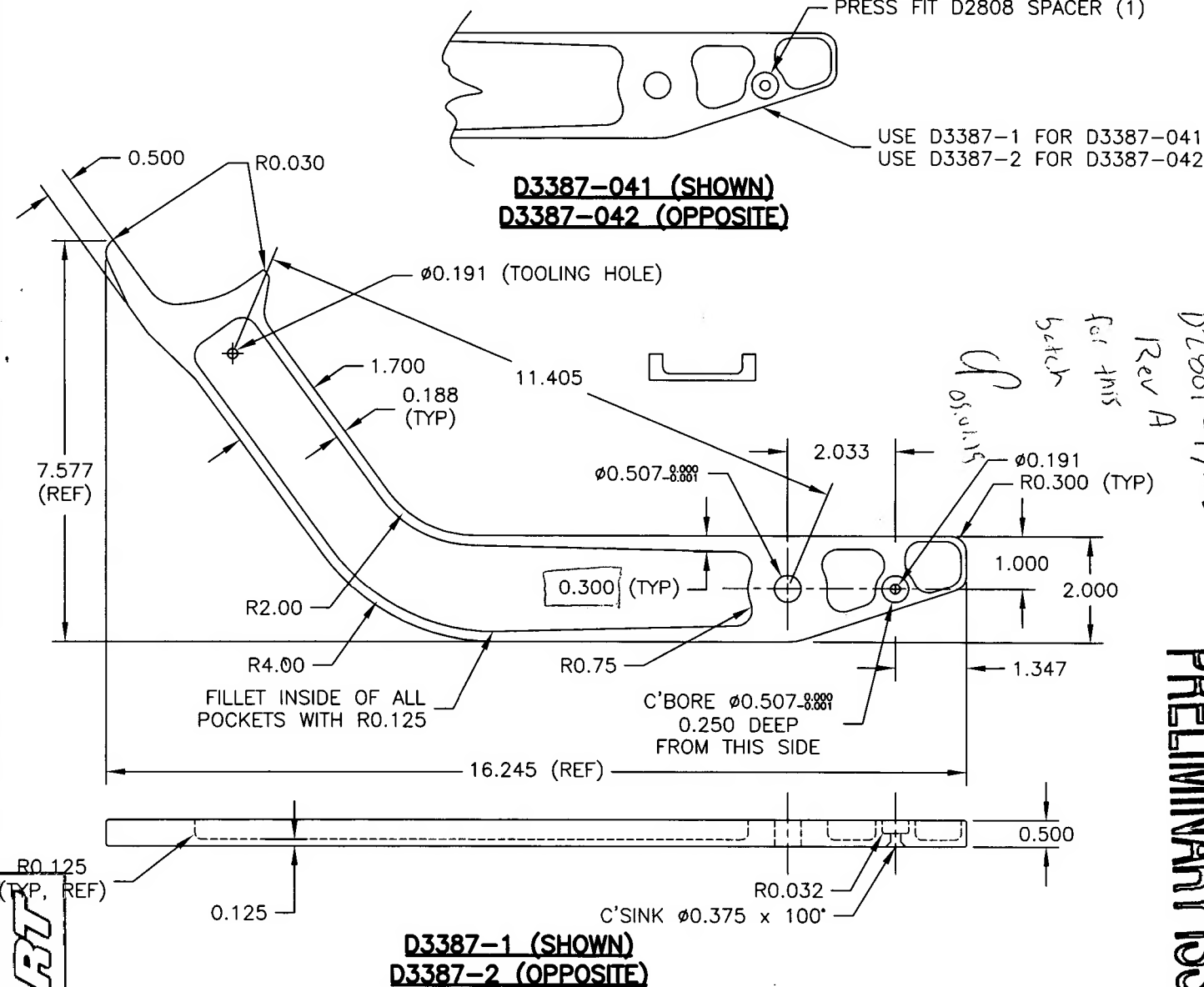
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	$\pm 0.016$	R0.125	✓		Vern	
0.135	$\pm 0.020$ $\pm 0.000$	0.150	✓		Hand Micro	
Ø0.375X100	$\pm 0.010$	Ø0.375X100	✓		Vern	
R0.032	$\pm 0.010$	R0.032	✓		R-G	
0.500	$\pm 0.016$	0.500	✓		Vern	
0.500	$\pm 0.016$	0.503	✓		Vern	
7.577	$\pm 0.016$	7.580	✓		H-G	
R0.125	$\pm 0.016$	R0.125	✓		Vern	
Ø0.507	$\pm 0.000$ $\pm 0.001$	Ø0.5065	✓		Micro/T-G	
0.250	$\pm 0.016$	0.247	✓		Vern	
1.347	$\pm 0.016$	1.347	✓		Vern	
2.000	$\pm 0.010$	2.006	✓		Vern	
1.000	$\pm 0.010$	1.000	✓		Vern	
Ø0.191	$\pm 0.005$ $\pm 0.000$	Ø0.194	✓		Vern	
R0.300	$\pm 0.010$	R0.300	✓		Vern	
2.033	$\pm 0.010$	2.033	✓		Vern	
0.280	$\pm 0.016$	0.283	✓		Vern	
0.222	$\pm 0.010$	0.223	✓		Vern	
1.700	$\pm 0.016$	1.704	✓		Vern	

Measured by: <i>JML</i>	Audited by: <i>EP</i>	Prototype Approval: <i>CP</i>
Date: 05/01/19	Date: 05/01/19	Date: 05/01/19

Rev A	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	







#### GENERAL NOTES

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	APPROVED	DRAWING NO.	REV. A
CHECKED	APPROVED	D3387	SHEET 1 OF 1
DATE	TITLE	ARM	SCALE
05.01.18	ARM	NEW ISSUE	1:3

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

1921



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 17, 2005  
10:23 am

Work Order No : 0022234  
Project Name : D2802-1  
Project For : WK505  
Work Order Type : Sub  
Main WO Number :  
House Part Number : D2802-1

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00

Description : Arm  
Manufactured : Yes  
Amount Req'd : 2  
Amount Done : 0  
Start Date : 01-17-05  
Est Finish Date : 01-24-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Order Entry No :  
OE Value : 0.00

Est Margin : 0.000%  
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00